

Date: Thursday, 27/11/2008 2:11:19 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X24")
Job Number	: 42036		
Estimate Number	: 10323		
P.O. Number	:	Part Number	: D206559013
This Issue	: 27/11/2008 S.O. No. :	Drawing Number	: D2432 REV F3
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 16/09/2008 Type : MACHINED PARTS	Drawing Revision	: F3
Previous Run	: 41228	Material	:
Written By	: <i>John 08.11.27</i>	Due Date	: 30/09/2008
Checked & Approved By	:	Qty:	4 Um: Each
Comment	Est Rev:J 04.02.17 Blank size changed KJ/JLM Est Rev:K 07-01-02 Was K10008 JLM Est Rev:L 08-01-09 Added Step 2 JLM Verified By:EC Est Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL


for JLD 08/09/24


Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-013 CHG005

509/01/02

2.0

MFG ENGINEERING

MFG ENGINEERING



Comment: MFG ENGINEERING

Program Batch Number

** John 08.11.27*

3.0

MUHMWB10

UHMW 1" Black



Comment: Qty.: 6.9878 sf(s)/Unit Total : 41.9265 sf(s)

• Material: Black UHMW 1"

(MUHMWB10)

Batch: *109186 IB 8-12-3*
(12)

4.0

WATER JET

FLOW WATER JET


IB 8-12-3


Comment: FLOW WATER JET

CUT BLANK

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

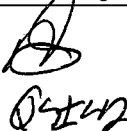
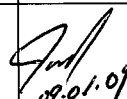
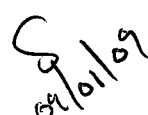
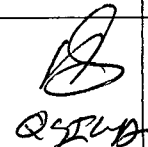

Note:(2) bearpaws for (1) Kit

B.A
08/22/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-559-013 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>42036</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/22	5.0	3 parts scrap (testing program) development C' Bone To Deep + Chatter		Scrap, Do Not Replace	 09.01.09	 09/01/09		

NOTE: Date & initial all entries

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Drawing Name: BEARPAW KIT (19"X24")

Job Number: 42036

Part Number: D206559013

Job Number:



Seq. #: Machine Or Operation: Description :

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

M.A 08/12/22

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 08/12/22

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

09.01.09

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

9.0

D2182B

Rubber Cushion



Comment: Qty.: 2.6000 f(s)/Unit Total : 15.6000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

42737

09/01/09

10.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2432F(ref only) Bearpaw

42099
4236

09/01/09

11.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp

41428

09/01/09

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 42036

Part Number: D206559013

Job Number:



Seq. #: Machine Or Operation: Description :

12.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : ~~72.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

41431 x 10
M42408 x 32

SS 09/01/09 (x4)

13.0

D2732

Rubber Extrusion



Comment: Qty.: 2.6000 f(s)/Unit Total : ~~15.6000~~ f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050

Rubber Cushion

38509

SS 09/01/09 (x4)

14.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : ~~72.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A

Bolt

M109148

SS 09/01/09 (x4)

15.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : ~~72.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

M109061

SS 09/01/09 (x4)

16.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : ~~144.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

M109249

SS 09/01/09 (x4)

Process Sheet

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Drawing Name: BEARPAW KIT (19"X24")

Job Number: 42036

Part Number: D206559013

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 MS21042L4 Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
12 MS21042L4 Nut (or -4)

M108145

JS 09/01/09 (4)

18.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 09/01/12 (4)

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-013

Location: _____

A 09/01/12 (4)

20.0 QC21 FINAL INSPECTION/W/O RELEASE



09/01/13 (4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-12

DART AEROSPACE LTD		Work Order: 42036
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063	✓		
B	5.500	+/-0.030	5.501	✓		
C	0.200	+/-0.030	0.203	✓		
D	0.25 x 45°	+/-0.030	0.250x45°	✓		
E	R0.250	+/-0.030	R0.250	✓		
F	0.250	+/-0.010	0.252	✓		
G	0.625	+/-0.030	0.627	✓		
H	0.375	+/-0.010	0.380	✓		
I	0.950	+0.030/0.010	0.955	✓		
J	19.000	+/-0.030	19.000	✓		
K	3.14	+/-0.030	3.128	✓		
L	3.28	+/-0.030	3.295	✓		
M	Ø0.260	+0.005/-0.000	Ø0.260	✓		
N	Ø0.93	+/-0.030	Ø0.927	✓		
O	0.30	+0.030/-0.000	0.305	✓		
P	23.750	+/-0.030	23.750	✓		
Q	7.375	+/-0.030	7.340	✓		
R	4.250	+/-0.010	4.252	✓		
S	2.000	+/-0.030	1.980	✓		
T	9.000	+/-0.010	8.996	✓		
U	9.000	+/-0.010	8.997	✓		
V	0.375	+/-0.010	0.375	✓		

Measured by: H.A	Audited by: [Signature]	Prototype Approval: N/A
Date: 08/12/22	Date: 09.01.09	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF	[Signature]



DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. F
SHEET 1 OF 2

DESIGN	DRAWN BY	DRAWING NO.	TITLE	SCALE
KE	KE	D2432	BEARPAW	1:6
CHECKED	APPROVED	DATE		
MM	MM	98.05.12		

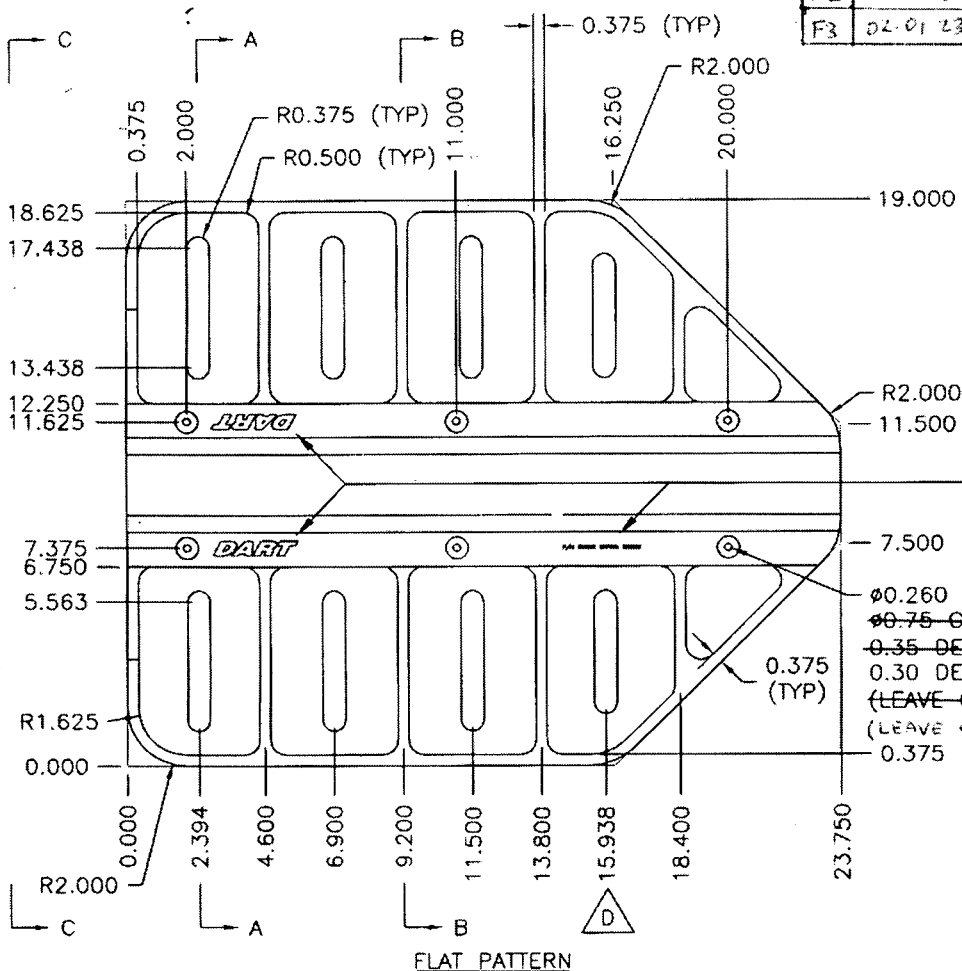
RELEASED
49.06.17 K6

A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

Ø0.260 (TYP)
Ø0.75 C'BORE & Ø0.93 C'BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375

EFFECTIVE DECS
9143



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

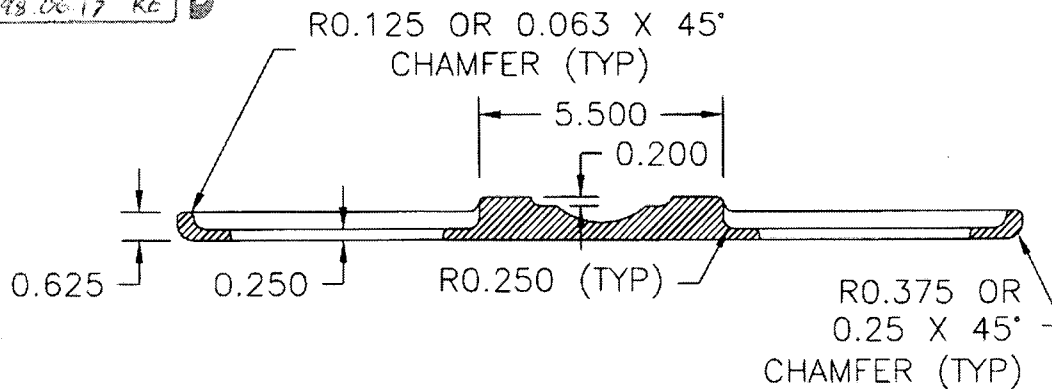
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42032

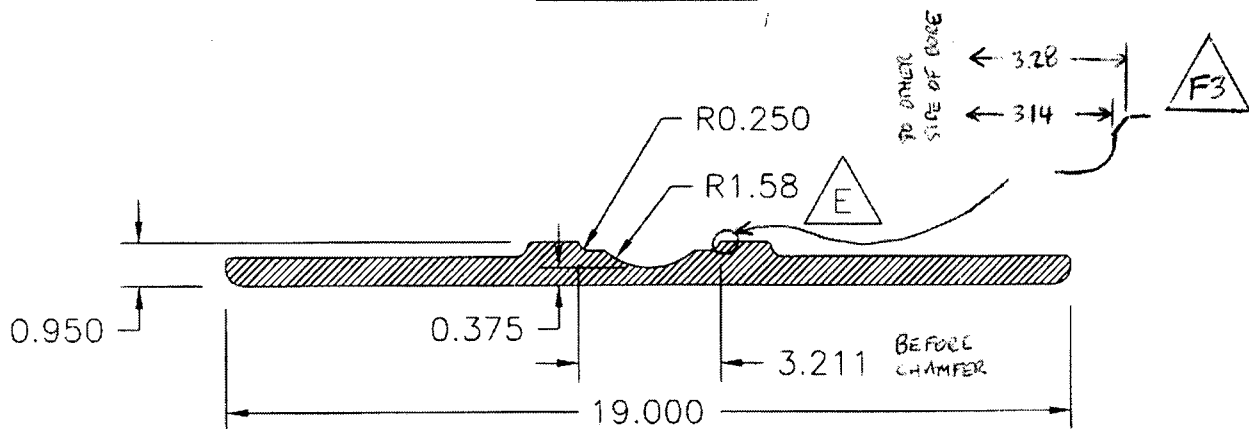


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MEK	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

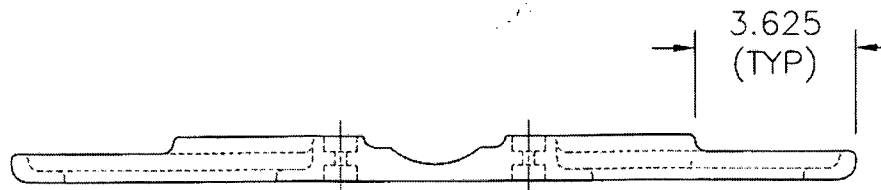
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

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